【Claims】

【Claim 1】

A method of manufacturing lashing bars of a composite material comprising,

(1) a step in which a forming mold for the aforementioned lashing bar is formed by assembling a cylindrical core featuring hook-type thimbles on one end and one or two ring-type thimbles on the other and then loaded onto a filament winding machine;

(2) a step in which continuous fibers are wound around the outer circumference of said loaded lashing bar forming mold through the filament winding technique; and

(3) a step in which the filament wound composite product is cured to form a lashing bar,

wherein the aforementioned step (2) consists of (2a) the sub-step of aligning the continuous fibers passed through the holes of said hook type thimbles lengthwise (0 degrees); (2b) a sub-step in which said continuous fibers are aligned at degrees not exceeding ±15 lengthwise along said cylindrical core; and (2c) a sub-step in which said continuous fibers are repeatedly aligned at ±40 to ±50 degrees to be wound.

【Claim 2】

The method as recited in claim 1, wherein the aforementioned step (1) is a process in which two ring-type thimbles are assembled on the other end of said cylindrical core so as to face each other.

【Claim 3】

The method as recited in claim 1, wherein the aforementioned sub-step (2) is a process in which the winding of the continuous fibers is repeated a certain number of times until the fibers are attached through the application of tension to the surface of the lashing bar forming mold in order of sub-steps (2a) to (2c).

【Claim 4】

The method as recited in claim 1, wherein whether eye-type lashing bars or knob-type lashing bars are manufactured can be chosen depending on the shape of said lashing bar forming mold.

【Claim 5】

The method as recited in claim 1, wherein said continuous fibers can be chosen among glass, carbon, aramid, and polyethylene fibers.

【Claim 6】

A lashing bar of a composite material manufactured through any of the processes recited in claims 1 to 5, wherein said lashing bar comprises a forming mold in which metal oval thimbles and ring-type thimbles are assembled on both ends of a metal cylindrical core, and filament-wound continuous fibers that pass the core of the axis along the holes of the exterior surface and thimbles.